

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024154**Date Inspected:** 28-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC TESTING

OBG 14 EAST

ZPMC NWIT No: 09280

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 14East. The weld designations are as follows:

SA8014-001-001~003, SA8014-002-001

SA8016-001-001

SA7034-001-033, 034

SA7035-001-003, 008

SEG3019AE-132, 137, 093, 098

SEG3019F-124, 127, 130, 133, 096, 101, 090, 095

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SEG3019R-117
SEG3019T-069
SEG3019P-057
SEG3019W-005
SEG3019AZ-004

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

SHIELDED METAL ARC WELDING PROCESS.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 037997 performing the Shielded Metal Arc Welding process on weld 147 located at PCMK SEG3019D-1-147. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067656 performing the Shielded Metal Arc Welding process on weld 014 located at PCMK SEG3019*. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 020 located at PCMK SEG3019*. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066258 performing the Shielded Metal Arc Welding process on weld 002 located at PCMK DP3160-001. ZPMC QC Mr. Wang Li Yang was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Tc-u4b-Fcm-1.

WELD REPAIR

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 058087 performing the Shielded Metal Arc Welding process on weld 167 located at PCMK SEG3019J. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Weld repair report identified as B-WR21029.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 215553 performing the Shielded Metal Arc Welding process on weld 003 located at PCMK SEG3019AH. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Fcm-Repair-1. Weld repair report identified as B-WR21107.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
